



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBD29826
Job Sheet 181022



Part No: RBD29826

Job Qty: 25 ea

Part Name: 4 Blade Tail Rotor Nut #369D21716-5 Torque Wrench Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/1/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via: DWG RBD29826 Rev 2

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea		8/1/18	0.00	0.00	Start Up Small Fab-4		RL
100	Small Fab	25 pcs		8/1/18	0.08	2.50	Small Fab-9		MLC DAS
110	QC	25 pcs		8/1/18	0.00	0.00	QC5		38
120	Outsource	25 pcs		8/1/18	0.00	0.00			9-89
130	Packaging	25 pcs		8/1/18	0.00	0.00	Packaging2		
140	QC	25 pcs		8/1/18	0.00	0.00	QC6		
150	Outsource	25 pcs		8/1/18	0.00	0.00			
160	Packaging	25 pcs		8/1/18	0.00	0.00	Packaging2		
170	QC	25 pcs		8/1/18	0.00	0.00	QC6		DAS
180	Packaging	25 pcs		8/1/18	0.00	0.00	Packaging3-2		21 AUG 1 2018
190	QC21-FG	25 Ea		8/1/18	0.00	0.00	QC21		21 AUG 1 2018

Part Op 100 - Assemble

Descriptions: 120 - Heat treat to RC 28-32

130 - Receive

150 - Black Oxide

160 - Receive

180 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A508	Dowel Pin 3/16" X 3/4"	50 Ea (2 ea)	90-Start up Operation	5084059
RBD29826-3	Torque Wrench Adapter 4 Blade	25 Ea (1 ea)	90-Start up Operation	5099559

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98381A508	50	100	0
	RBD29826-3	25	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

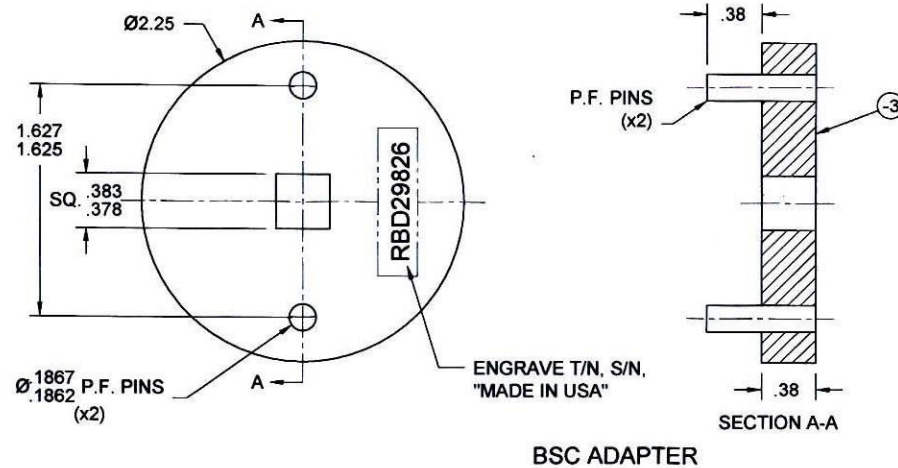
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspect ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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Date : _____		Step #: _____		Effective : _____		MRB (QSI042) Approval _____																																																	
Description Work Order Deviation: DART AEROSPACE Container No: S101091 Part: RBD29826 Job No: 181022 Serial No/Batch: S101091 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/10/16																																																							
Root Cause <table style="width:100%; font-size: 0.7em;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pr ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bl ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Conn. ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> <td></td> </tr> </table>						Environment ☐	No Re-verification ☐	Pr ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bl ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Conn. ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			Completed By _____ and / Supervisor oval Verification _____ C / QA Coordinator Approval _____	
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OTHER : _____																																																							

cd081022

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REV		DESCRIPTION	DATE	INITIAL	APPROVED
1		REDRAWN FROM 1980 DILAPIDATED PRINTS.	4/10/08	WP	RW
2		ADDED -1 HEAT TREAT 28-32 RC AND CH'D MATERIAL FROM STRESS PROOF. CH'D ENGRAVE NOTE.	8/2/12	RJC	SE



BSC ADAPTER

ASSY QTY	QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-3	1	ADAPTER	4140	3/8 X 2-1/2 X 2-1/2
		B/O		2	DOWEL PINS	HARDENED STEEL	Ø.187 x 3/4
ASSY #							

RED BARN MACHINE	
TITLE TORQUE WRENCH ADAPTER ASSEMBLY; FOUR BLADED TAIL ROTOR ASSY.	
DWG NO. RBD29826	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES Ø15 x 45° PR Ø15 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 4-10-08
SHEET 1 of 1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					